- The 3D printer is ready to work. To make it work you need computer and slicer software and some memory SD card.

- 3D printer has maximum printing area dimensions- e.g 210 x 210 180 mm.

- 3D printers are for indoor use only.

- It is necessary to keep printer in dry and stable environment. Do not do any big hardware modifications, because they may affect printer working.

- Highly recommend is to use 0.4mm extruder (standard) at first.

- Use touch screen or LC display with counter knob to operate the menu on the display.

- Use SD card as storage device.

- You can change settings manually during printing, but be sure what yous input will affect.

- You can print different materials- PLA, wood, flexible materials, ABS. Change setting in slicer program.

- Use **.stl** or **.obj** files for printing.

- Usable models and files can be CAD modeled or downloaded into web. You even can use 3D scanner for file creating.

- 3D printer creates a layer on top of a layer- ensure there is something to print on (printing into air and use supports if needed)

- Ensure your filament settings are right - temp, diameter, nozzle...

- The table moves up/down in the Z direction, left/right X directionand Y direction (forward / backward)

- All persons who operate, assemble, install, set up and put the products in service of the workshop must be properly trained and qualified, and must follow the operating instructions.

- 3D printer is not a toy and is not suitable for children. Children cannot judge the dangers while working - heat, electricity.

- 3D printer is not suitable for individuals who have some mental handycap or other disabled problems.

- Protect 3D printer from extreme temperatures, sunlight, strong tools, vibrations, flammable gases, steam, dust, solvents, solvents such as rain or steam, and strong mechanical tools.

- The mechanical parts of the device are manufactured very precisely. Never apply mechanical force to them. As a result, the 3D printer may become unusable.

- If safe operation is no longer possible, discontinue use and secure the product against re-use. Safe operation is not possible if the product:

  - is damaged,

  - does not work properly,

  - has been stored for a longer period in unfavorable conditions, or has been overloaded during transport.

- Handle the product with care. Shock, impact or dropping the product will damage it.

- The device must not be used in the vicinity of bathtubs, showers, swimming pools or sinks. The product must not get wet.

- Only use the device in moderate climates, never in tropical climates.

- Some parts of the device can become very hot and cause burns.

- Be careful around children and vulnerable people.

- Never reach into the 3D printer while it is in use. Moving mechanical parts inside the printer pose a high risk of injury!

- Do not place any objects on the product; to avoid overheating, do not cover the product when in use.

- The nozzle becomes very hot when operating. Do not touch it directly with your bare hands during or immediately afterwards. Let it cool down first.

- Never use the 3D printer outdoors.

- Never place containers containing liquids, such as glasses, vases, etc., on or near the device, and never pour any liquids over the device. Liquids can get inside the housing and adversely affect electrical safety. It also presents a great risk of fire or a potentially fatal electric shock! If this is the case, first switch off the power to the socket with all poles correct (e.g. switch off the fuse and the AC circuit breaker), then pull the power

cord out of the socket. Disconnect all cables from the device. Do not use any part of the product afterwards, but take it to a specialist workshop.

- Never place any naked flame sources, such as lighted candles, next to or on the apparatus.

- Never insert the plug into a socket immediately after moving the device from a cold to a warm environment. The resulting condensation may destroy the device. Allow the device to warm to room temperature before connecting. Wait for the condensate to evaporate.

- Do not cover the openings on the bottom of the product. Do not put any sharp objects into the product as this may cause electric shock!

- Do not leave a running product unattended.

- Under no circumstances should you service any components inside the 3D printer, so never disassemble the engine module.

- When setting up the 3D printer, make sure that the power switch on the back of the device is easily accessible so that in the event of a malfunction the device can be turned off quickly and easily.

- During operation, noise and smell will be emitted depending on the fiber material used. Keep this in mind when choosing the installation site and fiber materials. Provide adequate ventilation or install an extraction system. Do not inhale the resulting vapors. If other fiber materials than those recommended are used, poisonous fumes and gases may be produced.

- Observe the additional safety information in the individual chapters of these instructions.

- For safety reasons, any unauthorized adaptations and / or modifications to the product not in accordance with these operating instructions are not allowed. Components can be damaged and thus impair the function or safety of the device.

- If there are any doubts about the operation, safety or connection of the product, please contact a qualified technician.

- Maintenance, adjustment and repair work may only be carried out by an expert in a specialized company.

- If you have any questions that are not answered in this manual, please contact the 3D Incubator

- This device is a safety class 1 product. The only permitted voltage source is a properly grounded electrical socket (100-240 V / AC, 50/60 Hz) on the public line.

- Before connecting the 3D printer to the power supply, check that the AC voltage in your local network corresponds to the specifications on the nameplate (on the back of the 3D printer).

- Never touch the power cords or the power plug with wet or damp hands. There is a risk of potentially fatal electric shock!

- Do not let the power cord hang over the edge of a table or other surfaces the 3D printer is standing on.

- Completely unwind the cord before use supply. A power cord that is not fully extended can overheat and present a fire hazard!

- The socket outlet must be near the equipment and easily accessible.

- Never remove the plug from the socket by pulling the cord. Always use the handles on the sides of the plug.

- Remove the plug from the socket if you are not going to use the 3D printer for a long time.

- For safety reasons, remove the plug from the socket during an electrical storm.

- Remove the plug from the socket after use.

- Always unplug the product when it is left unattended.

- Disconnect the product from the power supply and the computer before maintenance or modification, and allow it to cool down.

- Make sure that the power cord is not crushed, bent, rubbed against sharp edges, or be subjected to any mechanical stress. Avoid excessive thermal stress on the mains cable due to contact with very high or low temperatures. Do not modify the power cord. Otherwise, the power cord may be damaged. A damaged power cord can cause a lethal electric shock.

- If the power cord is damaged, do not touch it. First switch off the relevant socket (e.g. with a circuit breaker) and then carefully pull the mains plug out of the socket. Never use the product with a damaged power cord.

To Start printing

- Press the control dial and select <Print from SD> in the <Main> menu

- Select a printable model, eg <RF100.gcode>. • Note that only .gcode files are shown in the menu

- <Info screen> appears on the LC display.

- The table moves to the zero position along the Z axis. The nozzle moves to the home position and begins to heat up.

- When the nozzle has reached the target temperature, printing begins.

- After printing, let the printed item cool down for a few minutes.

- While printing is paused, the nozzle continues to heat up. Therefore, pause printing only briefly, otherwise the nozzle will overheat and may become clogged.

- Press the control knob to exit the <Info screen> and enter the <Main> menu.

- Select <Pause print> to pause printing.

- To continue printing, select <Resume print>